

Work Order ID 72073

Friday, July 22, 2011 9:17:05 AM



MAT Black

Page 1

Item ID: D3405-043

Accept



Setup Start



Revision ID:

Item Name: Lug Assembly

Stop



Start Date: 7/19/2011 Start Qty: 2.00

Required Date: 7/29/2011 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Must Ship
Aug 10th

Approvals: Process Plan: *mk*

Date: 11-07-22

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3405	Rev B								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3405

Dwg Rev: *B*

Prog Rev: *B*

2-Deburr if necessary

B11-82

6

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-8-2

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Sulogloz

(Te)

PTD →

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11-08-11		ID + stock 4 x D3405-3 under same batch # 72073	MF	11-08-11	4		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Brake NC Brake NC	NC BRAKE Memo 1-Deburr 2-Form using DT8204 as per Dwg D3405 3- use DT9681 to check if correct forming	0.00 0.00				(6)			
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(46)			
150 Large Fab Large Fab	Weld per dwg A/R S.S. rod Batch: 117659 Large Fab Memo Weld as per Dwg D3405 use DT8484 Identify as D3405-043 M117659	0.00 0.00				X 2	11-08-11	200/Pl 11-08-11	

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

11-08-11 *(2)*

170

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Subs 14

(2)

186

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

11115

Memo

0.00

Powder Coating

START TIME:

8:00am

☐ OVEN TEMPERATURE:

8:20am ☐ FINISH TIME:

220°

2 *φ* *11/08/11*



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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(NOTE) Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							
200 Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00							
210 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

2x 11/08/12

11/8/12 sl(2)

CK 11/08/12

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Tuesday, July 19, 2011 9:05:28 AM

Page 1

Work Order ID: 72073



Parent Item: D3405-043



Parent Item Name: Lug Assembly

Start Date: 7/19/2011

Required Date: 7/29/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP A 05.09.01 New issue KJ/JLM
IPP B 09.01.28 Rev b dwg EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3404-1		Manufactured	No			100	Each	31.0000	1	2			
---------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

GHW Lug

Location Loc Qty Loc Code

WA 28

70664 28

WA030 3

67127 3

M304S11GA		Purchased	No			150	sf	79.0000	0.154	0.324211			
-----------	--	-----------	----	--	--	-----	----	---------	-------	----------	--	--	--

304/316 0.125 Sheet

Location Loc Qty Loc Code

MAT020 79

117494 79

72719 MF
11-08-11

1.
B11-8-2

117494

6

W/O:		WORK ORDER CHANGES					
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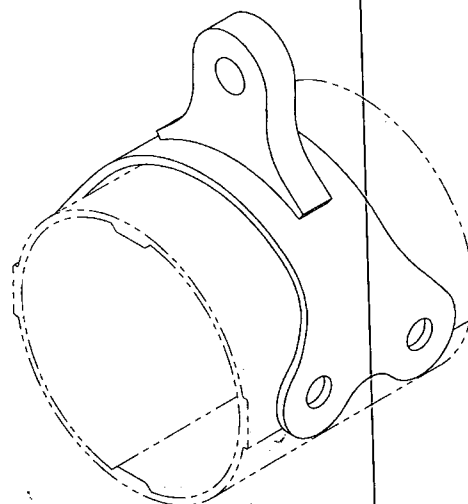
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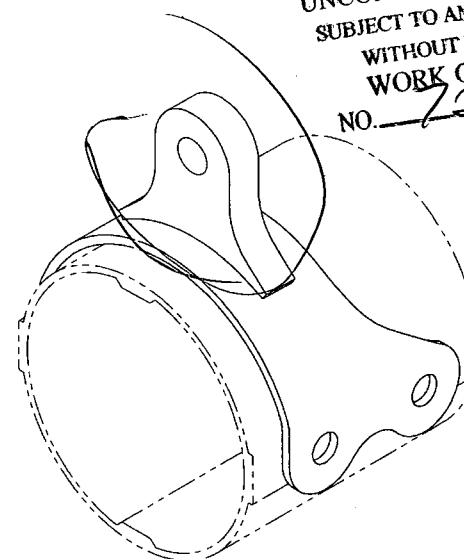
NOTE: Date & initial all entries

ITEM No.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
1	X		D3405-041	LUG ASSEMBLY
2		X	D3405-043	LUG ASSEMBLY
11	1	1	D3404-1	GHW LUG
12	1		D3405-1	GHW BRACKET
13		1	D3405-3	GHW BRACKET

△B



D3405-041 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)



D3405-043 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 72023

PH 11-07-19

RELEASED
08/12/18 M

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3405-041" USING FINE POINT PERMANENT INK MARKER
: IDENTIFY WITH DART P/N "D3405-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: -041, 0.85 lbs
-043, 0.87 lbs

B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERNS FOR -1 & -3 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198). SHEETS 3 & 4 ZONE A6 4.120 DIM WAS 4.100.		AJS	08.09.19
A	NEW ISSUE		PH	05.03.08
REV.	DESCRIPTION		BY	DATE
DESIGN	PH	DART AEROSPACE LTD		
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA		
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.		D3405	SHEET 1 OF 4	
APPROVED		TITLE	SCALE	
DE APPR.		GHW LUG ASSEMBLY	NTS	
DATE	08.09.19		COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

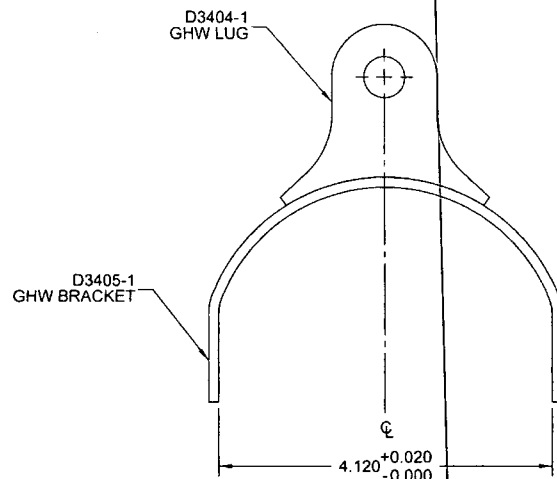
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

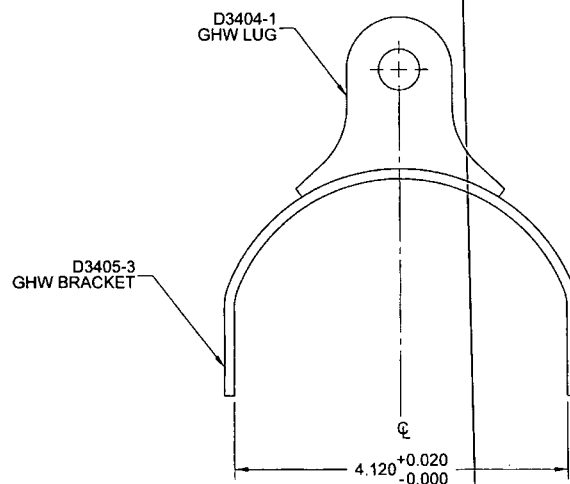
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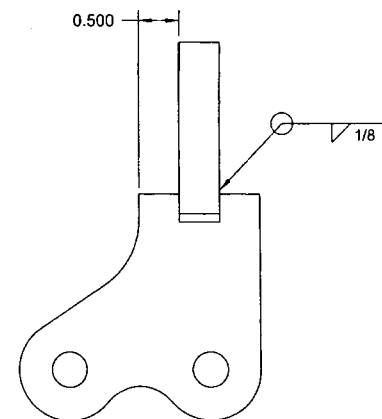
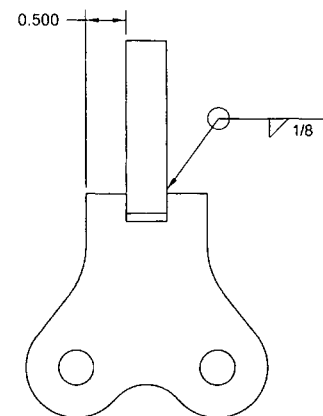
NOTE: Date & initial all entries



D3405-041 LUG ASSEMBLY



D3405-043 LUG ASSEMBLY



RELEASED
06/12/18

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 2 OF 4
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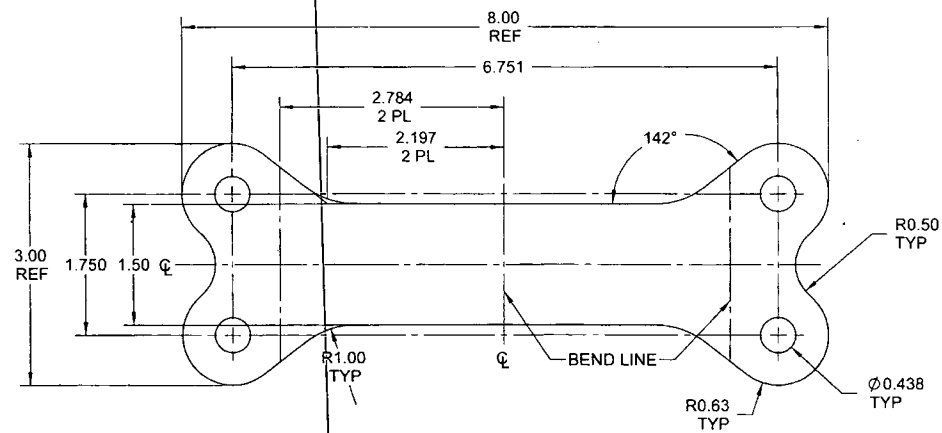
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

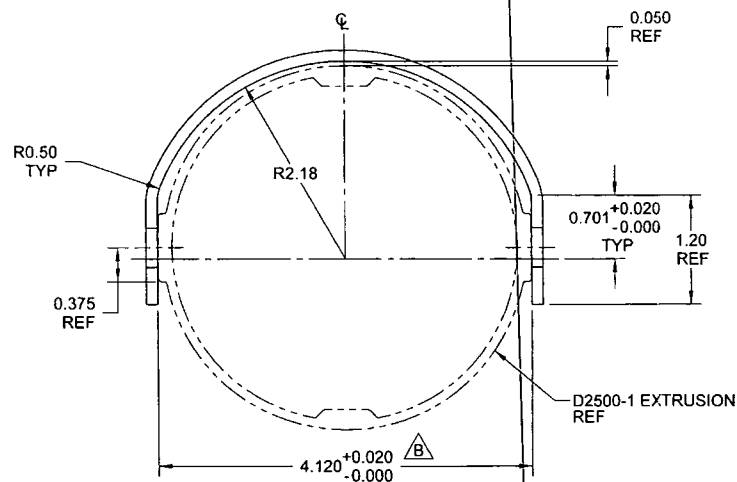
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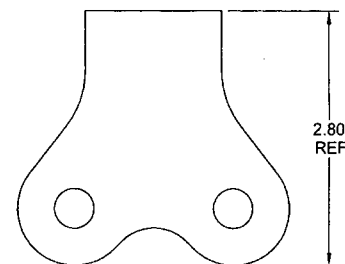
NOTE: Date & initial all entries



D3405-1F GHW BRACKET FLAT PATTERN



D3405-1 GHW BRACKET
(MAKE FROM D3405-1F)



SIDE VIEW FOR REF ONLY

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		GHW LUG ASSEMBLY	NTS
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RELEASED
08/09/19

72073

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72073

RELEASED
08/12/18 NW

2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: N/A

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3405 TITLE GHW LUG ASSEMBLY SCALE NTS <small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON OR ENTITY WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>
DRAWN	AJS	
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	08.09.19	

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